

Stop Dec 10

Dart Aerospace Ltd.

Date: Tuesday, 11/21/2006 1:15:39 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 412 GROSS WEIGHT TOWING KIT
Job Number	: 29605		
Estimate Number	: 12592		
P.O. Number	: N/A	Part Number	: D412666011
This Issue	: 11/21/2006 S.O. No. : <i>PLA</i>	Drawing Number	: D412-666 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL / MED FAB	Drawing Revision	: B
Previous Run	: <i>N/A</i>	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 12/10/2006 Qty: 14 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev:B Added GHG 002 NG 02-03-06		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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17

Comment: Photocopy bluefile & type labels per PPP412-666-011 CHG 002

KS 06 11.28

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

3.0	D2888	Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 28.0000 Each(s)

Lug

x Batch: *B29606*

4.0	AN615A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 56.0000 Each(s)

Bolt

x Batch: *M11134x5, M12490x47, M102832x4*

96 stock

3102832

5.0	AN643A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 56.0000 Each(s)

Bolt

x Batch: *M11325x11, M11600x34, M102832x10*

M102832x10

AB06/12/07

34

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ED Date: 06/12/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 GROSS WEIGHT TOWING KIT

Job Number: 29605

Part Number: D412666011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 112.0000 Each(s)

Washer

Batch: M101124 ✓

7.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 56.0000 Each(s)

Nut

Batch: M100151 ✓

06/12/07

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06/12/08 (14)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-666-011

Location: _____

PPP Rev: 0

06/12/08 (14)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/08

Job Completion



06/12/08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D412-666	REV. B SHEET 1 OF 1
DATE 02.03.04		TITLE 412 GROSS WEIGHT TOWING KIT	SCALE 1:3
A	99.05.03	NEW ISSUE	
B	02.03.04	UPDATE KIT FOR BOTH SKIDTUBES AND COMPATIBILITY WITH DART CROSSTUBES	

APPLICABILITY:

GROSS WEIGHT TOWING KIT D412-666-011 MAY BE INSTALLED ON DART D205-634-011 SKIDTUBES INSTALLED ON 412 AIRCRAFT TO ALLOW GROUND HANDLING AT GROSS WEIGHT IN ACCORDANCE WITH BELL SERVICE INSTRUCTION BHT-412-SI-58. IT IS ALSO ACCEPTABLE TO INSTALL THIS KIT ON 204/205/212 AIRCRAFT EQUIPPED WITH DART SKIDTUBES IN ORDER TO PRESERVE THE LIFE OF THE AFT CROSSTUBES. THIS KIT CONTAINS ENOUGH PARTS TO INSTALL D2888 LUGS ON BOTH SKIDTUBES.

PARTS LIST:

-011	PART	DESCRIPTION
X	D412-666-011	GROSS WEIGHT TOWING KIT
2	D2888	LUG
4	AN6-15A	BOLT
4	AN6-43A	BOLT
8	AN960JD616	WASHER
4	MS21042L6	NUT (or MS21042-6)

WEIGHT AND BALANCE:

INSTALLATION	WEIGHT	LONGITUDINAL	
		ARM	MOMENT
D412-666-011	1.90 lb 0.86 kg	163.0 in 4.14 m	310 in lb 3.56 m kg

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29605

PROCEDURE:

- 1) REMOVE AN6-12A BOLTS (4) ON INBOARD SIDE OF AFT SADDLE AND DISCARD. ON LANDING GEAR WITH DART AFT CROSSTUBES, REMOVE (4) AN6-40A BOLTS.
- 2) INSTALL D2888 LUGS WITH AN6-15A BOLTS (2) AS SHOWN IN FIGURE 1. USE AN6-43A (2) BOLTS ON DART CROSSTUBES, AS SHOWN IN FIGURE 2.
- 3) TORQUE BOLTS PER INSTALLATION INSTRUCTIONS D205-634.

